

Iupital™ F20-73R2

Mitsubishi Engineering-Plastics Corp - Acetal (POM) Copolymer

General Information

Product Description

VOC, Low; Viscosity, Medium

General

Features	- Low VOC - Medium Viscosity
Uses	- Automotive Applications - Electrical/Electronic Applications - Automotive Electronics - General Purpose

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	7.9	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.00 mm)	2.0	%	Internal Method
Water Absorption - 60% RH (23°C)	0.20	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2900	MPa	ISO 527-1/1
Tensile Stress (Yield)	63.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	9.0	%	
Break	30	%	
Flexural Modulus ²	2600	MPa	ISO 178
Flexural Stress ²	89.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	156	°C	ISO 75-2/B
1.8 MPa, Unannealed	100	°C	ISO 75-2/A
Melting Temperature	166	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow	1.1E-4	cm/cm/°C	
Transverse	1.1E-4	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Electric Strength			IEC 60243-1
1.00 mm	32	kV/mm	
3.00 mm	19	kV/mm	

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Electrical	Nominal Value	Unit	Test Method
Dielectric Constant			IEC 60250
1 MHz	3.90		
100 MHz	3.90		
Dissipation Factor			IEC 60250
1 MHz	7.0E-3		
100 MHz	2.0E-3		
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	HB		UL 94

Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature - Hot Air Dryer	80	°C	
Drying Time - Hot Air Dryer	3.0 to 4.0	hr	
Rear Temperature	170	°C	
Middle Temperature	180	°C	
Front Temperature	190	°C	
Nozzle Temperature	180 to 210	°C	
Mold Temperature	60 to 80	°C	
Injection Pressure	50.0 to 100	MPa	
Injection Rate	Moderate		
Screw Speed	80 to 120	rpm	

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 mm/min

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